

Date: Friday, 10/13/2006 9:30:41 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	28969		
Estimate Number :	12463		
P.O. Number :		Part Number :	D35085
This Issue :	10/13/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3508 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	27712	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/30/2006
Written By :		Qty:	12 Um: Each
Checked & Approved By :	<i>[Signature]</i> 06/10/13		
Comment :	Est Rev:A New Issue 06-06-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.6549 sf(s)/Unit Total: 7.8586 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S20GA)
 Batch: ~~1101463~~ M100473

546 06:10:21
per PH

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: A
 Prog Rev: per

546 06:10:21

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

546 06:10:21

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

06.10.25

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form on brake using DT8326 and DT8261 as per Dwg D3508

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/13/2006 9:30:41 AM
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Drawing Name: WEARPLATE

Job Number: 28969

Part Number: D35085

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.03.13

Dart Aerospace Ltd

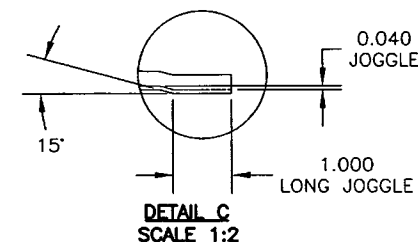
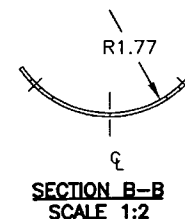
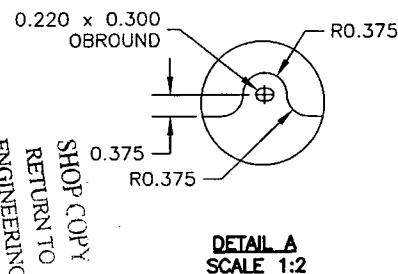
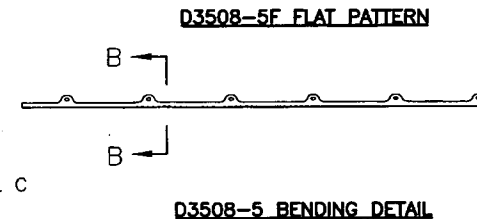
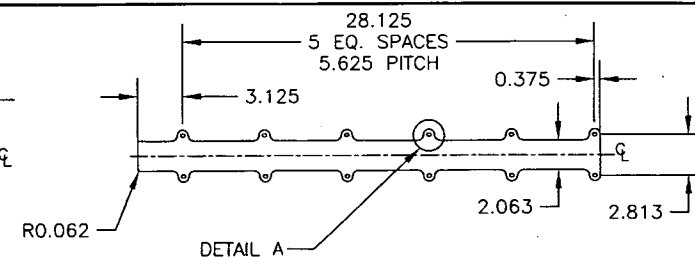
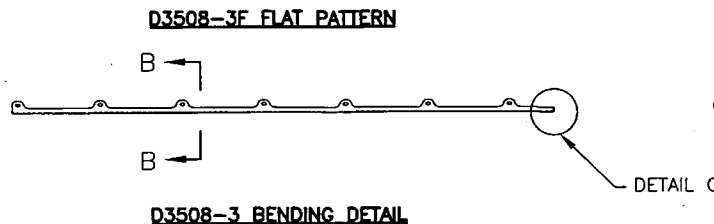
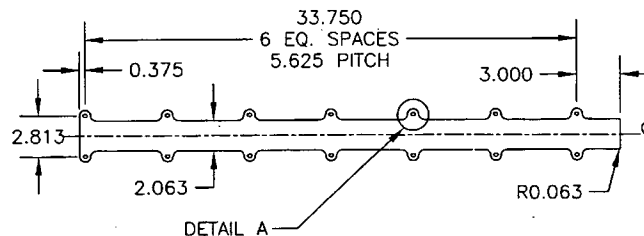
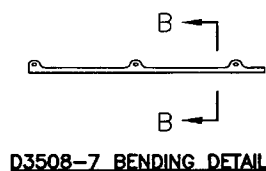
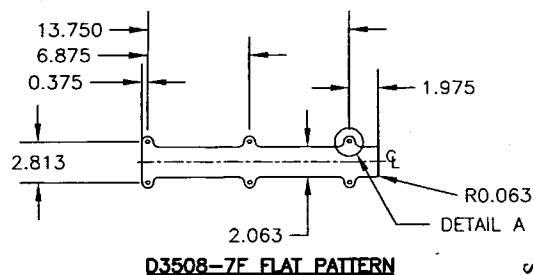
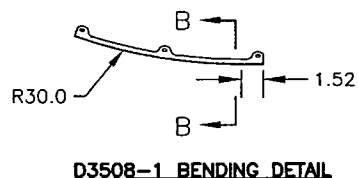
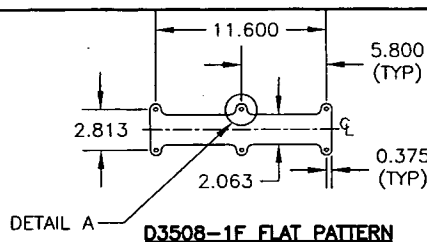
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK) (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
NO. 28169
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE

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A	06.04.21	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	#	APPROVED
DATE	06.04.21	TITLE
		WEARPLATE
		DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3508
		REV. A
		SHEET 1 OF 1
		SCALE
		1:1

RELEASED
06.10.03 PH
per ECR #891

